

Work Order ID 78408

January-09-12 8:58:15 AM

78408

Ship B JAN Page 1

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 09/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 23/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100 Weld per dwg A/R S.S. rod Batch M117884 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

QC12-01-17

1x Ø

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

B.E.
 12-01-18

1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating									

m 115128

*** mask sides of hinge prior to powdercoat***
 Start Time: 2:00
 Oven Temperature: 320°F
 Finish Time: 2:30

140	Wing Walk as per dwg QSI005 4.4 Batch <u>120125</u>	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label

IXC M-12/01/18

1 BK 12-1-18

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: DH030-CH1	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12-1-19

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Picklist Print

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Page 1

Work Order ID: 78408

78408

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2581

Manufactured

No

100

Each

81.0000

2

2

**

Pl 12.01.12

D2581

Mounting Bracket

Location

Loc Qty

Loc Code

WA005

81

69739

1

70766

2

75280

1

77045

48

77523

29

(2)

D3914-1

Manufactured

No

100

Each

4.0000

2

2

**

Pl 12.01.12

D3914-1

Rib

Location

Loc Qty

Loc Code

WA

4

77144

4

(2)

D3914-7

Manufactured

No

100

Each

0.0000

2

2

**

B78695 -> (2) Pl 12.01.17

D3914-7

Rib

D4016-3

Manufactured

No

100

Each

15.0000

3

3

**

Pl 12.01.12

D4016-3

Hinge Half, Lid

Location

Loc Qty

Loc Code

WA005

15

74909

15

(3)

W/O:		WORK ORDER CHANGES					
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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100 Each

1.0000

9 9

D4018-5

Rib

**B77813 → ⑨ PL12-01-12

Location

Loc Qty

Loc Code

WA005

1

74917

1

D4020-5 Manufactured No

100 Each

1.0000

1 1

D4020-5

Mesh (350 Basket Long, Lid)

** PL12-01-12

Location

Loc Qty

Loc Code

WA

1

75551

1

D4021-3 Manufactured No

100 Each

0.0000

1 1

D4021-3

Data Plate

** B75460 → ① PL12-01-17

D4035-041

Manufactured No

100 Each

2.0000

1 1

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

** PL12-01-12

Location

Loc Qty

Loc Code

WA006

2

76332

2

D4035-043 Manufactured No

100 Each

0.0000

1 1

D4035-043

Lid Rib Assembly, Aft (350 Basket)

** B76545 → ① PL12-01-17

D2728-3

Manufactured No

140 Each

0.0000

1 1

D2728-3

Dart Logo label

** 1 PL12-01-18

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Shop Packet Print

Page 2

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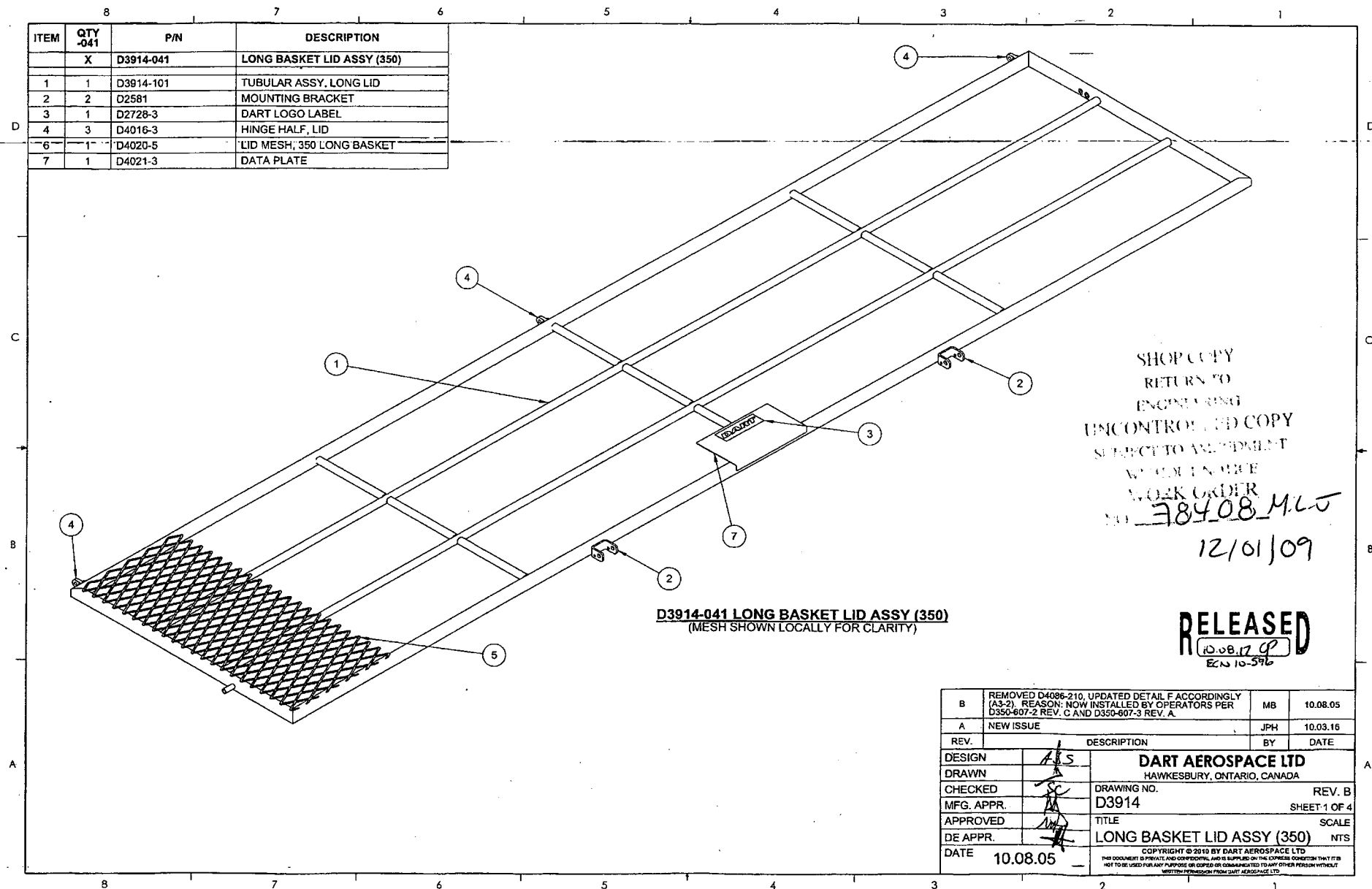
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



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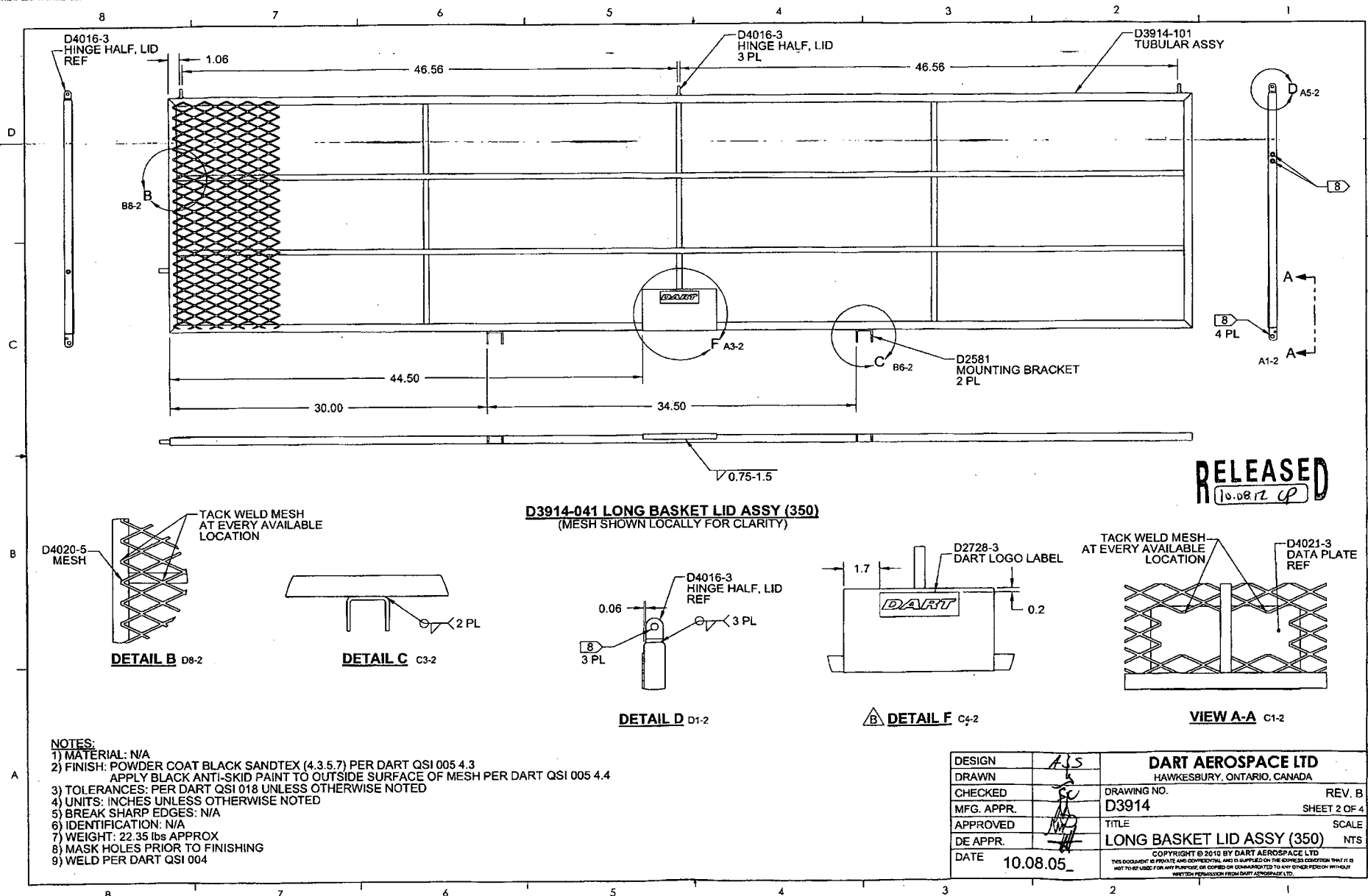
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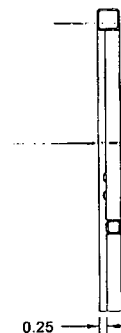
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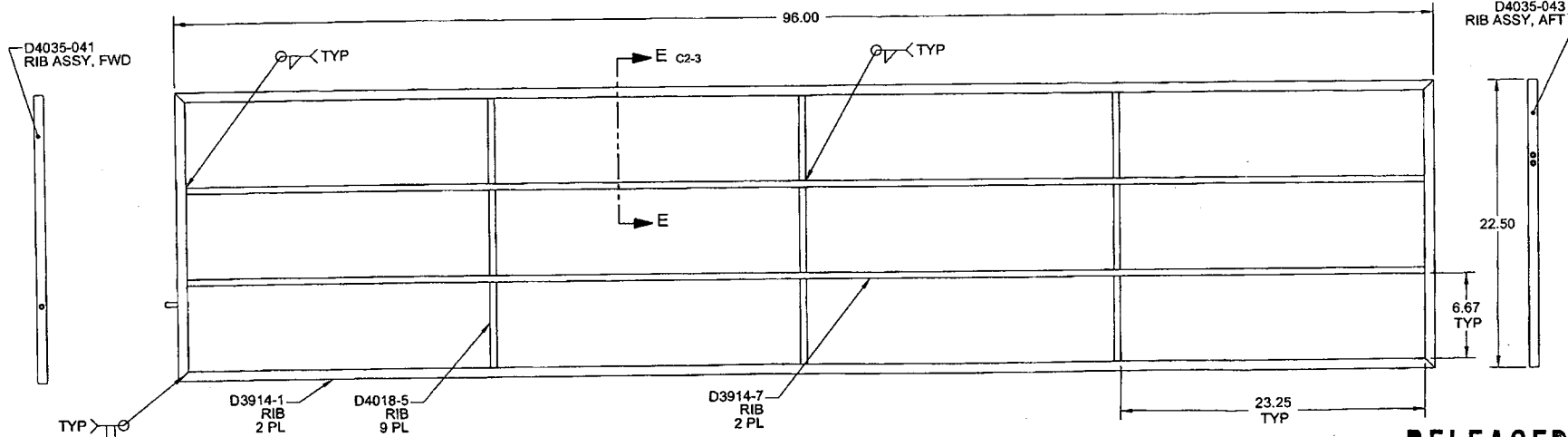
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

RELEASED
10-08-05

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D3914	REV. B
MFG. APPR.	ALS		SHEET 3 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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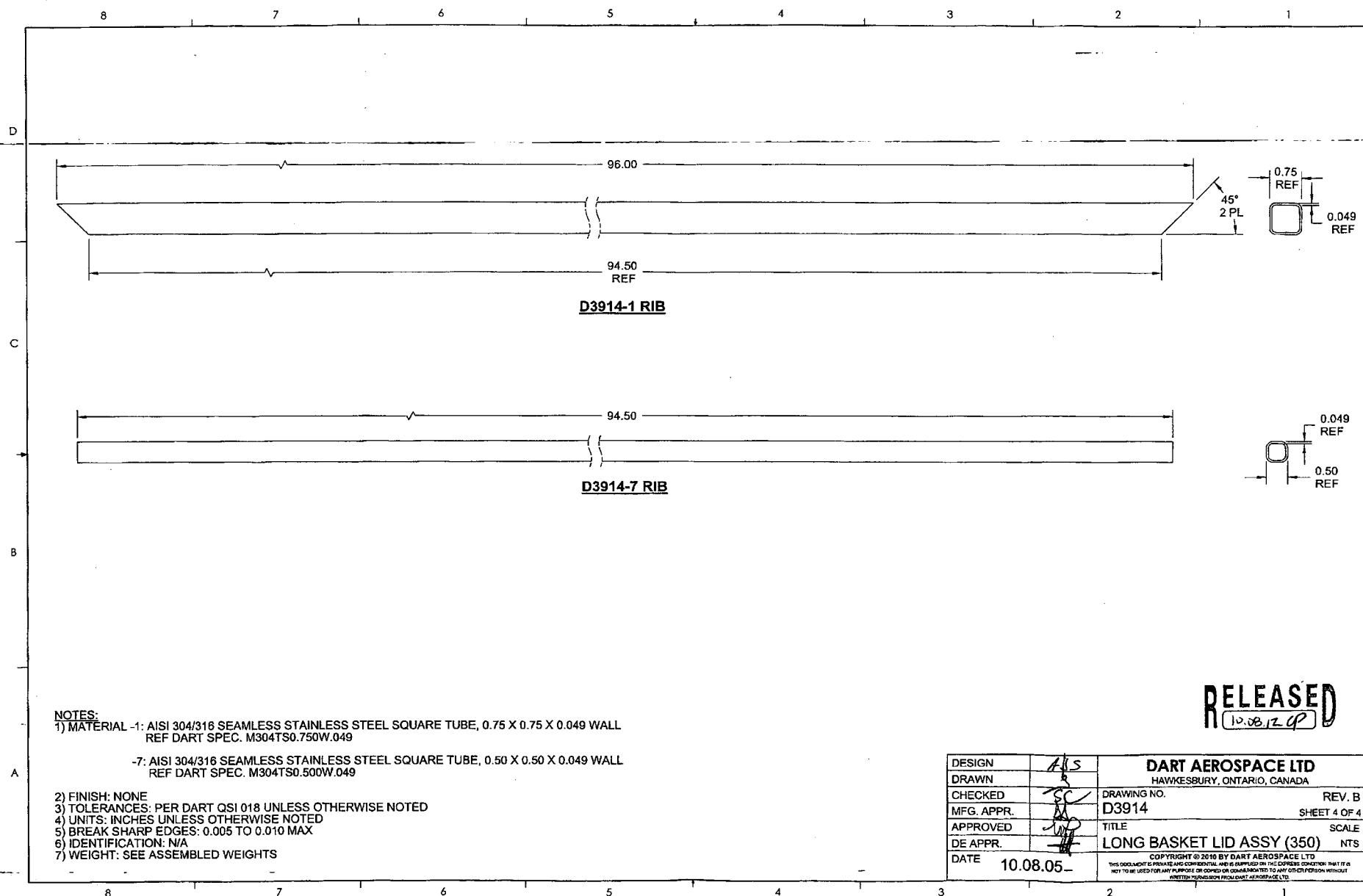
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 GP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	
DATE	10.08.05	NTS	

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